\$AP *106634*

Work Orde September-11-1.	er ID 106634 3 11:10:32 AM	. ,	*106	3634*						Page 1	
Revision ID:	D3077-1 Step Leg		Accept	*N900	<u>040</u>	100)* s	etup Sta	1.71	S1* S2*	
~	9/11/13 Start Qty: 8.0	00 *8	* 44)*	Cust Item 1 Customer:	D:				I		
Approvals:	Process Plan:	Date:	Tooling:	D	ate:	-	F	Run Sta	I <i>N</i>	R1*	
•	QC:	Date:	SPC (Y/N):	D	ate:			Sto	^{pp} *N	R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										_
D3077	Rev B									*	
*100 *100* Waterjet FLOW CNC Waterjet	FLOW WATER JE Memo 1-Cut a Deburr		0.00 0.00 g Rev: S Prog Rev:_ S	3 _2-			41	0		Ae 13.19	.02
110	QC2- Inspect parts	off machine FAI/FAIB	0.00							,	
110 QC Quality Control	Мето		0.00	~			41	•		Ae 13:18	9.09
120	QC8-Inspect parts	- second check	0.00 DAS 27	\			41				
120 QC Quality Control	Мето		9.89 [] [2]	103		G	and				

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
										QA Closed:	Date	:
Work Orde	r:		·	,	DISPOSITION				AGAINST DE	PARTMENT	_	
Part No.				Rework Scrap Use-as-is		ľ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other	
NCR No.					Work Order Update] ['		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Init	tial	Acti	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief	f Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data						1						
Equip/Tooling	_											
Operator										ļ		
Material			Ì									
Setup												
Other	_											
Process												
Supplier	_	*										
Training	_											1
Unapproved			<u> </u>		_							
						AULT (CATE	GORY				
Landir	ng Gear				General					7	-	 1
	Bending			<u> </u>	Bend	\vdash	rain		<u> </u> _	Ovalized	<u> </u>	Pressure/Forced
	_	ot Conce	ntric to	o/s	BOM/Route	\vdash	ardwa		_	Over/Under		Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	•	on Incomplete		Part Incorred	}	Weld
		/Crimped		-	Burrs	\mathbf{H}		ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs			ļ	Contamination	₩.		nance	<u> </u>	Part Moved		
	Heat Tre			<u> </u>	Countersink	\vdash	lislabe		<u> </u>	Positioned V		7
	— i	on Strip in	Tube	<u></u>	Cut Too Short	\vdash	lisreac	1	L	Power Loss/	Surge	Other
	Ripples i	n Bend		<u></u>	Drill Holes	\vdash	ffset					
Torque Waves in Extrusion		n	Drawing		ut of (Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 106634 September-11-13 11:10:32 AM			*106	6634*						Page 2	
Item ID: Revision ID: Item Name:	D3077-1 Step Leg			Accept	*N900	040	100)* s	Setup Star Stop	ıu.	S1*
Start Date: Required Date: Reference:	9/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item II Customer:	D:				IV.	7/
Approvals:		lan:	Date:			te:		F	Run Star Stop	1/11	₹1* ₹2*
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr to tal	ke measurement	Set Up/ Run Hours 0.00	Tool ID DAS 27 9-89	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* HandFinish Hand Finishing		Chemical Conversion Co	oat per QSI005 4.1	0.00				41	NE	81318:	3
150 *150* QC Quality Control		OC3 Inspect Part Finish Memo		0.00 DAS 0.00 27 9-89 0.00 B	103		C.	4)			

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Machining Prod. Eng. Coor. Quality Part No. Small Fab Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Sign & Action Root Initial Qty Chief Eng Verification Date Cause Date Step or Non-conformance Description QC Inspector Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Over/Under tolerance Hardware Temperature/Cure Broken/Damaged Inspection Incomplete Weld Cracks Part Incorrect Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Cuffs Maintenance Contamination Part Moved Mislabeled Heat Treat Countersink Positioned Wrong Inspection Strip in Tube **Cut Too Short** Misread Power Loss/Surge Other **Drill Holes** Ripples in Bend Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 106634 September-11-13 11:10:32 AM				*106			Page 3		
Item ID: Revision ID: Item Name:	D3077-1 Step Leg		or and the second secon	Accept	*N900	04010 0) * ፡	Setup Start Stop	14.51
Start Date: Required Date Reference:	9/11/13 e: 9/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item I Customer:	D:			
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ate:	1	Run Start Stop	"NR I"
Sequence ID/ Work Center 160 *160* QC Quality Control	ID	Operation Description QC5- Inspect part comp Memo	leteness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
170 Packaging Packaging		Identify as per dwg & S Memo	tock Location: <u>iMA</u> .600	0.00 0.00			_41	- - 19 -	
*1 A \ * QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					12/04 1

N3-12-4

DQA:	Date:	
	•	······································

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Da	te:	
Work Order	·:				DISPOSITION			AGAINST	DE	PARTMENT	/PROCESS		
Part No	0				Rework Scrap Use-as-is Work Order Update] 	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Prod. Eng. Coor. Q Rec/Store/Packaging			Engineering Quality Other
Root		· .		Descri	ption of work order update	Initia	al	Action		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Description		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training													
Unapproved			l			AULT C	ATE	CORV		<u> </u>			
Landin	a Goor				General	AULI C	AIE	JORT					
·	Bending Centre No Cracks Crushed/		ntric to	o/s	Bend BOM/Route Broken/Damaged Burrs	Inst	rdwa pecti	re on Incomplete ions Incomplete/Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi	ct		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled
-	Cuffs Heat Trea	at	Tube		Contamination Countersink Cut Too Short	Ma		nance led		Part Moved Positioned V Power Loss/	Vrong		Other
, †	Ripples in	•			Drill Holes	\blacksquare	set	•		1 - 1 - 2 - 2 - 2 - 2 - 2 - 2 - 2 - 2	0 -		
	Torque V		Extrusio	n	Drawing	_		Calibration			<u> </u>		
	Turning S	Sequence			Finish	Ou	t of S	equence					
			Folio	Ou	tside	Dimensions							

Picklist Print

September-11-13 11:10:31 AM

Work Order ID:

106634

Parent Item:

Comments:

D3077-1

Parent Item Name:

Step Leg

IPP Rev: B02.11.18Incorporated D3170-1 IPPKJ

IPP Rev: C

06-04-27 Manufactured on Water Jet JLM

	IPP Rev: D 0	6-06-23	Now 60)61-T6	JLM								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	T	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased	No			110	sf	645.5800	0.5833	4.912	1	. •	
6061-T6 .080 Sheet											Ne	<u> 13 '</u>	12.05
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT021		645.58							
					125812	32.75							
				1	n126309	363.5						^-	
				ı	m126350	249.33			12	6350	>	25	.16

Required Date: 9/11/13

Required Qty: 8.00

Start Date: 9/11/13

Start Qty: 8.00

DQA: Date:

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

WCIN.					WORK ORDER NOW				QA Closed:	Date	::
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	-1	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	The	rmoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Er	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling		•									
Operator											
Material											
Setup		İ				*					
Other		į									
Process		Ì									
Supplier		1									
Training [İ	
Jnapproved [<u> </u>					
					F	AULT CA	regory				
Landir	ng Gear	·			General			_	_	_	_
	Bending				Bend	Grain	1		Ovalized	L	Pressure/Forced
. [Centre N	ot Conce	ntric to (o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct [Weld
	Crushed/	Crimped			Burrs	Instru	ctions Incomplete/	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved		_
	Heat Trea	at			Countersink	Misla	beled		Positioned \	Wrong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	'Surge	Other
ļ	Ripples in	n Bend			Drill Holes	Offse	t				
	Torque V	Vaves in I	Extrusio	n [Drawing	Out	f Calibration				·
	Turning 9	Sequence	!		Finish	Out	of Sequence				
	Wave/Tv	vist in Tul	be		Folio	Outs	de Dimensions				

DART AEROSPACE LTD	Work Order:	106634
Description: Step Leg	Part Number:	D3077-1
Inspection Dwg: D3077 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
11.958	+/-0.010	11.958	_		τ	JKmrob
11.250	+/-0.010	11.250	,		T	JKm 205
2.250 Pitch	+/-0.010	2,250	<i>-</i>		V	JKm 205
Ø0.213	+0.005/-0.000	. 213	-			
0.551	+/-0.010	,551	1		V	
5.016	+/-0.010					
Ø0.128	+0.005/-0.000	.129			V	
0.354	+/-0.010	,354			V	
5.024	+1- ,010	5,023			V	

		DAS		
Measured by:	Audited by:	27	Prototype Approval:	N/A
Date: 13.12.02	Date:	13/12/03	Date:	N/A

R	ev	Date	Change	Revised by	Approved
	Α	05.04.26	New Issue	KJ/JLM	1
	В	06.06.23	Dwg Rev. changed	KJ/JLM	
	-			· · · · · · · · · · · · · · · · · · ·	/ /

